Work Ord Monday, July 1				*122	294*							Page 1
Item ID: Revision ID: Item Name:	D3637-3 Bracket			Accept	*N900	040	100	)*	-	Start Stop		S1* S2*
Start Date: Required Date Reference:	7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	<b>`</b> ,		Cust Item 1 Customer:	ID:					···IVI	<b>7</b> 2"
Approvals:	Process Pla	an: MLJ	Date: 14-67-15	Tooling: SPC (Y/N):		ate:				start Stop		R1* R <i>2</i> *
Sequence ID/ Work Center I	( <b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Iumber	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3637	Rev	v B										
100 *100*	}	FLOW WATER JET		0.00				9			DAS <b>46</b> 9-89	14/08/2
Waterjet FLOW CNC Water	rjet	Memo 1-Cut as	per Dwg D3637	0.00							9-89	1110012
		Dwg Rev Prog Rev 2-Deburn	v: 3 v: 3 r if necessary		r					4		
110		QC2- Inspect parts of	ff machine FAI/FAIB	0.00							DAS	

0.00

Memo

\*110\*

Quality Control

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wa	ork Order up	odate only	AERŌSP.	ĀCĒ
QA Closea.			Date.									······································	, ,	<u> </u>	
Work Orde	er:				į	DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	_	
	-				<del></del>	Rework			Skid-tube	Crosstube			Water Jet	Engineering[	
Part N	lo.					Scrap		1	Machining	Small Fab		4	d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	Other	
NCR I	١o.					Suspected Unapproved			Large Fab	Composite		j	Supplier	] [	
Root					Desc	ription of work order update	l	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspect	or
Design															
Doc/Data															
Equip/Tooling														:	
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training	Ш														
Transport															
Unapproved			l	<u></u>								ļ			
							FA	ULT CA	TEGORY					***************************************	
Landi	ng (	ear `			_	General		1.			_	7	_	<b>-1</b>	
		Bending			<u> </u>	Bend	<u> </u>	4	Program		<u> </u>	Outside Dim	<u> </u>	Pressure/Forced	1
		l	ot Concer	ntric		BOM/Route	_	Grain			<u> </u>	Over/Under	<b>—</b>	Set-up	
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			_	Part Incorre		Temperature/Cu	ure
	_	Crimp/Ki	nk/Ripple	:/Wave	<u> </u>	Burrs	<u> </u>	4 '	ion Incomplete/Ui	-	<u> </u>	Part Lost/M	· ·	Weld	
		Cuffs				Contamination	_	- 4	tions Incomplete/I	Unclear	<u> </u>	Part Moved	<u> </u>	Wrong Stock Pu	lled
	_	Crushing			$\vdash$	Countersink		- '	gned/off center		<u> </u>	Positioned \	· -	٦٠٠٠	
		Heat Trea			<u> </u>	Cut Too Short	$\vdash$	Mislab				Power Loss/	'Surge	Other	
		Inspectio		Tube	$\vdash$	Drawing	_	Misrea							
	_	Marks/Cl				Drill Holes	_	Off-set							
	$\vdash$	1	Sequence		L	Finish	L	4	Calibration						
	1	Wave/Tv	vist in Tul	рe		Fit/Function		Out of	Sequence						

Work Ord Monday, July 1				*122	294*					Page 2
Item ID: Revision ID: Item Name:	D3637-3 Bracket			Accept	*N900	04010	<b>10</b> *	Setup Star Stop	17	S1* S2*
Start Date: Required Date Reference:	7/14/14 : 7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:				. 7/
Approvals:		an:		Tooling: SPC (Y/N):		ate:		Run Star Stop	VI"	R1* R2*
Sequence ID/ Work Center 1	I <b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla	_	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC8- Inspect parts - sec  Memo	ond check	0.00			<u>(P)</u>			DAS 38 9-89/4-8-25
130 <b>*130*</b> Brake NC Brake NC		NC BRAKE <b>Memo</b> Form as pe	Dwg D3637	0.00		DAS 30 9-89	9			ylo
140 <b>*140</b> *		QC5- Inspect part comp	leteness to step on W/O	0.00		DAS 27 9-89	19			

0.00

\*140\*

Quality Control

Memo

DQA:			. Date:										TAAC"
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Work Orde	er: _						.				7	\#/a+a=  a+	
Part N	lo.					Rework Scrap			Skid-tube	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo. <sub>-</sub>					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	ription of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design				·									
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material							1						
Operator													
Offset/Setup													
Process				•									
Supplier													
Training													
Transport							1						
Unapproved													
							FA	ULT CA	TEGORY				
Landir	ng G	Gear				General					<u></u>		_
		Bending			[	Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect	Г	Hardwa	are		Part Incorre	cí [	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
		Heat Tre				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d			_	
		Marks/C				Drill Holes		Off-set					
	$\vdash$	4	Sequence			Finish		-1	Calibration			**	
1	-	4 -	vist in Tul			Fit/Function		Out of	Sequence				

W	ork	Order	ID	122294
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\*122294\*

Page 3

Monday, July 1	4, 2014 1:55	::18 PM			794						1 460 5	
Item ID: Revision ID: Item Name:	D3637-3 Bracket			Accept	*N900	040	100	<b>)</b> * §	Setup Star Stop	17	S1* S2*	
Start Date: Required Date Reference:	7/14/14 :: 7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	* <u>8</u> * *8*		Cust Item :	ID:				T.V.		
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Stop	^1\ <u>\</u>	R1* R2*	
Sequence ID/ Work Center I	ID ·	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*150* Small Fab			s as per dwg using DT8979 les as per dwg	0.00				<b>-9</b> ×	DAS 28 9-89	<del>-SEP 3</del>	0- <b>2014</b> —	
160 *1 AN* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00				(9)		****	DAS <b>38</b> 9-89	4-10-07
170 <b>*170</b> *		Chemical Conversion C	oat per QSI005 4.1	0.00				$\widehat{q}$	Ø	14-	10-81	11,1
HandFinish HandFinishing		Memo		0.00					<del>/</del>	<u>·                                     </u>		

DQA:			Date: _										TQAG"
						WORK ORDER NON	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Order						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOLK OTGET	. —					Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part No	o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					_	Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No	o					Suspected Unapproved			Large Fab	Composite	]	Supplier	
		T	-					· i	<b>A</b> -		Cian 0		
Root	_		<u>.</u>	٥.	Desc	ription of work order update	1	nitial		tion	Sign &	Verification	QC Inspector
Cause	<u>                                   </u>	ate	Step	Qty		or non-conformance	Cn	ief Eng	Desc	ription	Date	Verification	QC IIIspector
Design	-												* . 3
Doc/Data	-												·
Equip/Tooling Handling/Pre	$\dashv$												
Material	_				i,								
Operator	- 1	3		]									
Offset/Setup	7	}											· · · · · · · · · · · · · · · · · · ·
Process		}											
Supplier													
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							FA	ULT CA	regory				
Landin	_					General	_	1		_	<b>-</b>		¬
-		nding			<u> </u>	Bend	<u> </u>	4	Program	_	Outside Dim	<b>⊢</b>	Pressure/Forced
	_		t Concer	ntric	<u> </u>	BOM/Route		Grain			Over/Under	H-	Set-up
<u> </u>	<del></del> -	acks			-	Broken/Damage/Defect	-	Hardwa			Part Incorre	<b>—</b>	Temperature/Cure Weld
-			k/Ripple	/Wave	-	Burrs	-	-i '	ion Incomplete/U	· ·	Part Lost/Mi Part Moved	-	
<del> </del>	Cu				-	Contamination Countersink	$\vdash$	4	tions Incomplete/ gned/off center	<u> </u>	Positioned V	<u>L.</u>	Wrong Stock Pulled
\ \		ushing at Trea				Cut Too Short	-	Mislab	=	<u> </u>	Power Loss/		Other
[	-		ι η Strip in	Tube	-	Drawing	-	Misrea		<u>t_</u>	الـ دون الـ دون الـ		1300
-		arks/Ch		TUDE	-	Drill Holes	$\vdash$	Off-set				· • • • • • • • • • • • • • • • • • • •	
		-	equence		-	Finish		4	Calibration				·
			ist in Tub		-	Fit/Function		-	Sequence				

<b>Work Ordo</b> <i>July-14-14 2:25</i>		122294		*122	294*							Page 4
Item ID: Revision ID: Item Name:	D3637-3 Bracket			Accept	*N900	040	10	<b>N*</b>	Setup	Start Stop	171	S1* S2*
	7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item 1 Customer:	ID:					· iv	.J/"
Approvals:	Process 1	Plan:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description	£	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
180		QC7-Inspect Chemical C	Conversion Coat	0.00								DAS 38
*1 QO* QC Quality Control		Мето		0.00				(9)	) — —	<del></del>		9-89 14-18
190		ldentify as per dwg & St	ock Location: <u>572</u> L	14 A								
*100* Packaging		Memo		0.00							DAS 	
Packaging		меню		0.00							9-89	
200		QC21- Final Inspection	- Work Order Release	0.00					1.1	i /	h	$\Omega$
*200*		Memo		0.00					_14	110	17_	

Memo

Quality Control

14/10/9/72) MF 14-10-59.

## **Picklist Print**

Monday, July 14, 2014 1:55:17 PM

Work Order ID: 122294

\*122294\*

Parent Item:

D3637-3

\*D3637-3\*

Parent Item Name: Bracket

**Start Date: 7/14/14** 

Required Date: 7/14/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	114.1911	0.134	1.128421	D40		
*M2024T3 2024-T3 .050 sheet	35 050*								**		9-89	1.6.	
		•		Location		Loc (	<u>Oty</u>	Loc Code			ਤ <b>-03</b>	iqi	108/23
				MAT022		114.1	911						
					124643	53.7	911		<del></del>				
					m128354)		48		(_	1.6			
					m128713		12.4		_		_		

DQA:			Date:										TRACC
						WORK ORDER NON-	-CC	NFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	= -					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	Proc	d. Eng. Coor.	Quality
	•	*		•		Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	١o.					Suspected Unapproved			Large Fab	Composite		Supplier	] []
			, ,				ᆜ				C: 0		1
Root		_			Desc	ription of work order update	ı	nitial	Act		Sign &	Verification	QC Inspector
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	vernication	QC inspector
Design	$\dashv$												
Doc/Data										•			
Equip/Tooling													
Handling/Pre	$\dashv$		ļ									i	
Material	$\vdash$				Į								ĺ
Operator Offset/Setup	Н	·											
Process	H												
Supplier	$\vdash$	·	l										
Training	H						Ì						
Transport			1										
Unapproved			]						-				
							FA	ULT CA	TEGORY				
Landi	ng (	Sear				General	_			<del></del>	<b>-</b> 1	_	<del>-</del>
		Bending				Bend		4	Program	<u> </u>	Outside Dim	_	Pressure/Forced
	<u> </u>	Centre N	ot Concei	ntric	L	BOM/Route	$ldsymbol{ld}}}}}}$	Grain		ļ	Over/Under		Set-up
		Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa			Part Incorre	_	Temperature/Cure
		Crimp/Ki	nk/Ripple	e/Wave		Burrs	$\vdash$	1 '	ion Incomplete/Ui		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination	<u>_</u>	4	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
		Crushing			$oxedsymbol{oxed}$	Countersink		-1	gned/off center		Positioned V		٦٠٠٠
	<u>_</u>	Heat Tre				Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other
		Inspection		Tube		Drawing		Misrea					*****
		Marks/Cl				Drill Holes	-	Off-set					
		4 -	Sequence			Finish		4	Calibration				
Wave/Twist in Tube Fit/Function Out of Sequence							Sequence						

DART AEROSPACE LTD	Work Order: 127294	
Description: Bracket	Part Number: D3637-3	
Inspection Dwg: D3637 Rev: B	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

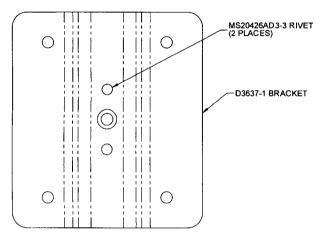
	X First Article Prototype											
	X	First Artic	le	Proto	type							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments						
4.50	+/-0.030	4.49	V									
4.97	+/-0.030	4.96										
0.050	+/-0.010	0,050										
	-											
- 18												
				•	,							
	DAS											
	AC		DAS-	<u> </u>								

 Measured by:
 9-89
 Audited by:
 9-89
 Prototype Approval:
 N/A

 Date:
 14/08/23
 Date:
 14-8-25
 Date:
 N/A

Rev	Date	Change	Revised by	Approved
Α	08.12.01	New Issue	KJ/EC 🚓	7
				•

-MS21059L4 NUT PLATE



D3637-041 BRACKET ASSEMBLY (WAS GENEVA P/N G10602-1)

## D3637-041 PARTS:

D

QTY	P/N	DESCRIPTION BRACKET ASSEMBLY	
Х	D3637-041		
1	D3637-1	BRACKET	
1	MS21059L4	NUTPLATE	
2	MS20426AD3-3	RIVET	

- D3637-041 NOTES:
  1) MATERIAL: N/A
  2) FINISH: N/A
  3) TOLERANCES: N/A
  4) UNITS: N/A
  5) BREAK SHARP EDGES: N/A
  6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
  7) WEIGHT: 0.27 lbs

С

SHOPCOPYRETURN TO ENGINEERING UNCONTROLLED COPY ENC.

ONTROLLE.

BJECT TO AMENDMEN.

WITHOUT NOTICE

NO. 122294 M LJ

(407-1)

TORK ORDER

	~~···					
В	FOR D36	37-1, 1 15 WAS	LE	07.12.18		
Α	NEW ISSUE; REPLACES G10608, G10602 & G10609				07.07.27	
REV.	DESCRIPTION			BY	DATE	
DESIGN		TS	DART AEROSPACE LTD			
DRAWN		1=	HAWKESBURY, ONTARIO, CANADA			
CHECKED		PA	DRAWING NO.		REV. B	
MFG. APPR.		620	D3637	SHEET 1 OF 3		
APPROVED		W	TITLE		SCALE	
DE APPR.		d	BRACKET		1:1	
DATE 07.12.18			COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONSIDENT HAS THE NOT TO BE USED FOR ANY PROPOSE ON COMPANIENTED TO ANY OTHER PRISON WITHOUT			

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